

Date: Wednesday, 2/15/2006 3:47:48 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD ASSEMBLY LH
 Job Number : 25851
 Estimate Number : 10800
 P.O. Number : NIA Part Number : D350600141
 This Issue : 2/15/2006 S.O. No. : NIA Drawing Number : D3186 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : SMALL /MED FAB Drawing Revision : A1
 Previous Run : 25300 Material : NIA
 Due Date : 3/10/2006 Qty: 1 Um: Each
 Written By : See Comment Below
 Checked & Approved By : 06.02.16
 Comment : Est Rev:D 06/04/14 Incorporated procedures from D3187-1/-2 K J/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-141 CHG002

KS 06.03.07 ①

2.0 25851A SPACEPOD BODY LH



Comment: Sub-Component SPACEPOD BODY LH

3.0 25851B SPACEPOD DOOR LH



Comment: Sub-Component SPACEPOD DOOR LH

4.0 D31871 Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3187-1	Floor	B22929 B22929
1	D3186-1	Door (ref)	25851B
1	D3188-1	Body(ref)	25851A

5.0 ALS41032130 Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
28	ALS4-1032-130	Insert	M18293

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-1. Open holes in floor to Ø0.297". Install inserts as per Dwg D3188.

ml 06/06/12

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-06-14

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open holes in D3187-1 as per Dwg 3187

2-Deburr D3187-1

*Floor already
completed from
the previous Batch
D3187-1 B22929*

AO

ml 06/06/12

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-06-14

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005-4.1

N/A

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

N/A

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A

13.0 D2986 Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total: 5.9010 sf(s)

Pick:

Qty Part Number

Description

Batch

B24628

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.06.14	8	Flt is A-1 for LH Assy. Please change		E	06.07.12			06.06.14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25851

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.62SF D2986 Neoprene Foam

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement Batch:

ml 06/06/14

already done

N/A

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2179 Hinge Bracket Plate

B21490

17.0

D2219

Door Prop Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2219 Door Support Bracket

B14027

18.0

D2228

Backing Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2228 Backing Plate

B14028

19.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D2237 Strike Plate

B25327

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D2464

3/4 Seal



Comment: Qty.: 10.9305 f(s)/Unit Total : 10.9305 f(s)

Pick:

Qty Part Number Description Batch

1 D2464-125" neoprene Seal

B25153

✓

21.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D2586 Latch

1x B25050

2x B26079

✓

22.0

D2588

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D2586 Latch

mounting channel
1x D2588 B21509

✓

23.0

D2589

Keys, Key Chain



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2589 Mounting Channel

Keys, Key chain
1x D2589 B26031

✓

24.0

D2621

Latch Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D2621 Latch Plate

B25474

✓

25.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2857-1 Hinge Bracket

B26501

✓

These are miped

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D350600141

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0	D28572	Hinge Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2857-2 Hinge Bracket B 26034

27.0	D2977	Hinge Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2977 Hinge Bracket B14106

28.0	D2978	Hinge Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2978 Hinge Bracket B14107

29.0	D2982041	Prop Arm Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2982-041 Prop Arm Assembly B24627

30.0	D30153	Lock Nut
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3015-3 Lock Nut B22365

31.0	A3235020935	Washer - Countersunk
------	-------------	----------------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 A3235-020-935 Washer M18332 M18332 mil

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25851

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN526C832R9

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN526C832R9 Screw m 15602

✓

33.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN960JD10 Washer m 100743

✓

34.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD516 Washer m 15927

✓

35.0

AN960JD8

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 AN960JD8 Washer m 11989

✓

36.0

AN960JD8L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960JD8L Washer m 6956

✓

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 25851

Part Number: D350600141

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

37.0	MS20426AD45	Rivet
------	-------------	-------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batc
6 MS20426AD4-5 Rivet m3459

PTO

38.0	MS21042L08	Nut
------	------------	-----



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number Description Batch
14 MS21042L08 Nut (or -8) m100564

39.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 MS21042L3 Nut (or -3) m15539

40.0	MS270390810	Screw
------	-------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 MS27039-0810 Screw m5865

41.0	MS27039125	Screw
------	------------	-------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 MS27039-1-25 Screw m17570

42.0	SL69BS	Ball Stud
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 SL69-BS Ball Stud m16948

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
06/06/12	37.0	Permanent change: add in Pick list 2X Rivet MS 20426-AD6 M2566 They missing	ml		2		<i>[Signature]</i> 06/07/12		
		These rivets are not in the system or Dwg E 06.07.12				DWG / ICA CURRENTLY UNDER REVIEW OK TO RELEASE DEL TO FOLLOW	<i>[Signature]</i> 06/07/12		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:47:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25851

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-2 door with D3188-2 body as per Dwg ICA-D350-600

ml 06/06/14

PTD

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188-2 & QSI 005 4.4

Batch: *11/01/266*

11/06/27 (1)

45.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

06-07-10 (1)

46.0

K10018

Spacepod Hardware Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 K10018

Spacepod Hardware Kit

26013

1 D3187-1(Ref)

Spacepod Floor

1322929

06/07/11 (1)

47.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/07/11 (1)

48.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location:

PPP Rev: *C*

06/07/11 (1)

49.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/13 (1)

Job Completion



06-08-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-07-10	43.0	QC 5 for Assy → by seel to estimate permanent change	J	06-07-10	1	J	J
			E	06-07-13			06-07-10

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
06/06/12	43.0	The door and Body don't fit well. Grind the body, put gloo <u>M100008</u> and prime <u>M109111</u>	J			ml 06/06/14	J 06-06-14	J	J 06-06-14

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED GP	DRAWING NO. D3186	REV. A SHEET 1 OF 3
DATE 03.03.27		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
AI	GP 04.11.04	NEW 4.5" WIDE UNIDIRECTIONAL	

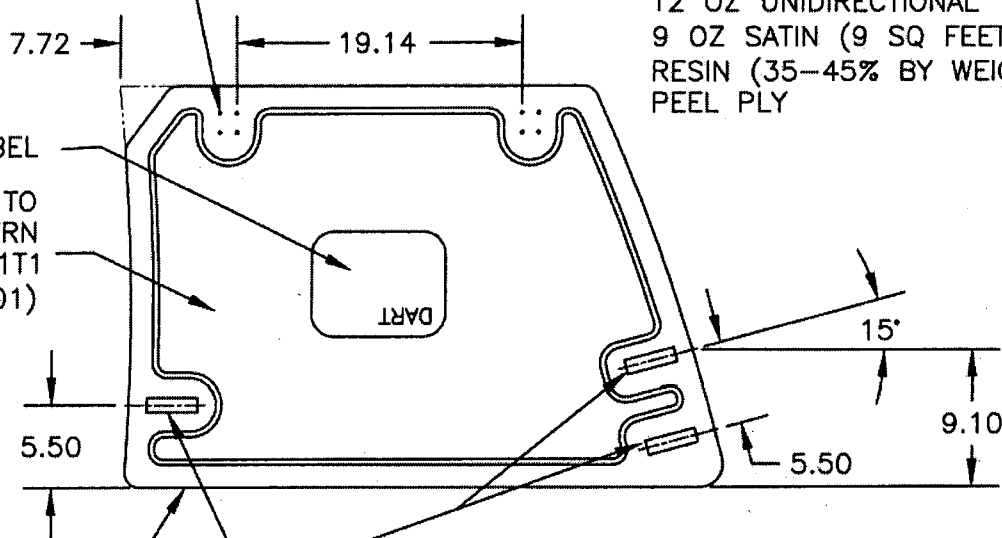
DRILL 8 HOLES $\phi 0.171$
PER SCRIBE LINES OF
MOLD DT8005 (REFER
TO DETAIL B ON PAGE 3)

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

D0600-145 LABEL

ROUTER FOAM TO
ROUTER PATTERN
D3186-1T1
(P/N D3186-101)



12 OZ UNIDIRECTIONAL
4.5" WIDE 5" WIDE ALONG
OUTSIDE EDGE

CUT 3 PLACES AS SHOWN IN DETAIL A
ON PAGE 3

RELEASED
#03.04.22

D3186-1**NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25851

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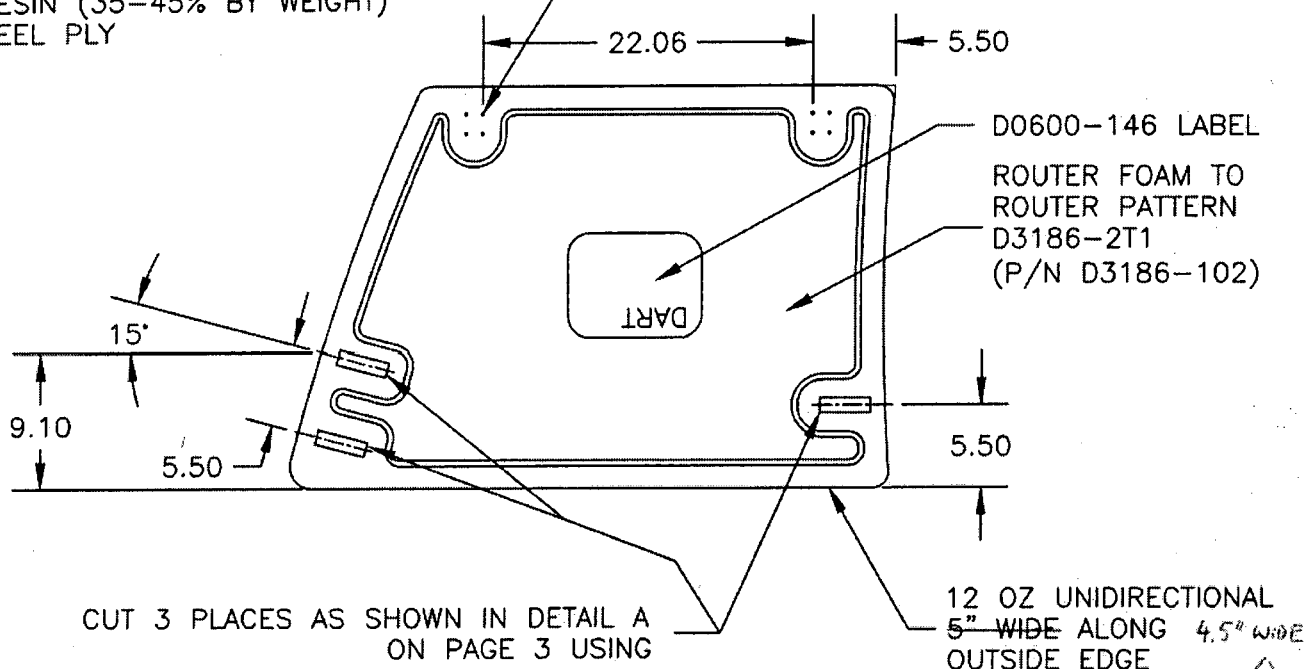


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3186	REV: A SHEET 2 OF 3
DATE 03.03.27		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

DRILL 8 HOLES $\phi 0.171$
PER SCRIBE LINES OF
MOLD DT8006 (REFER
TO DETAIL B ON PAGE 3)



RELEASED
030422

D3186-2

NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

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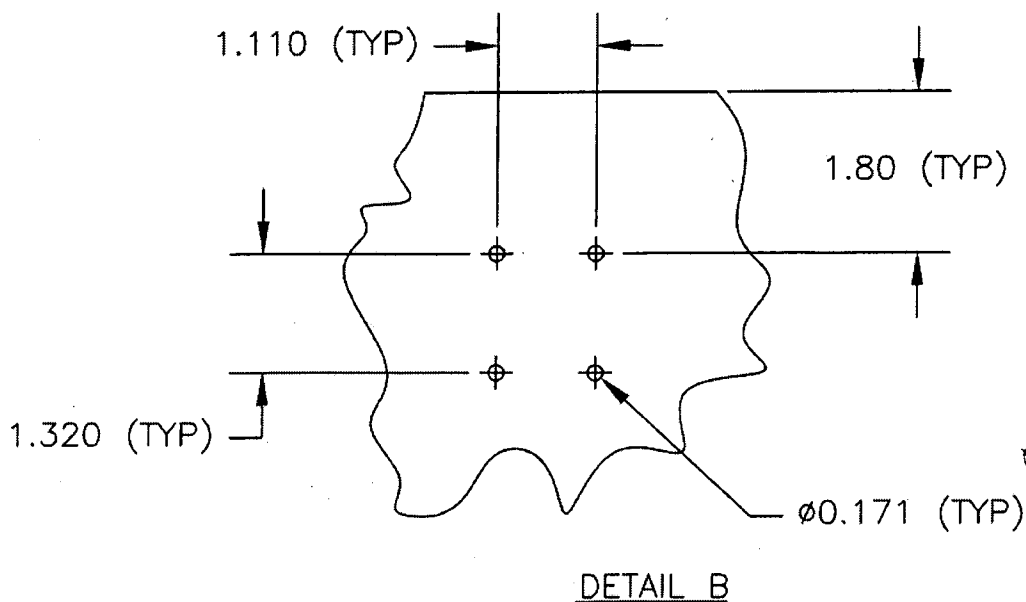
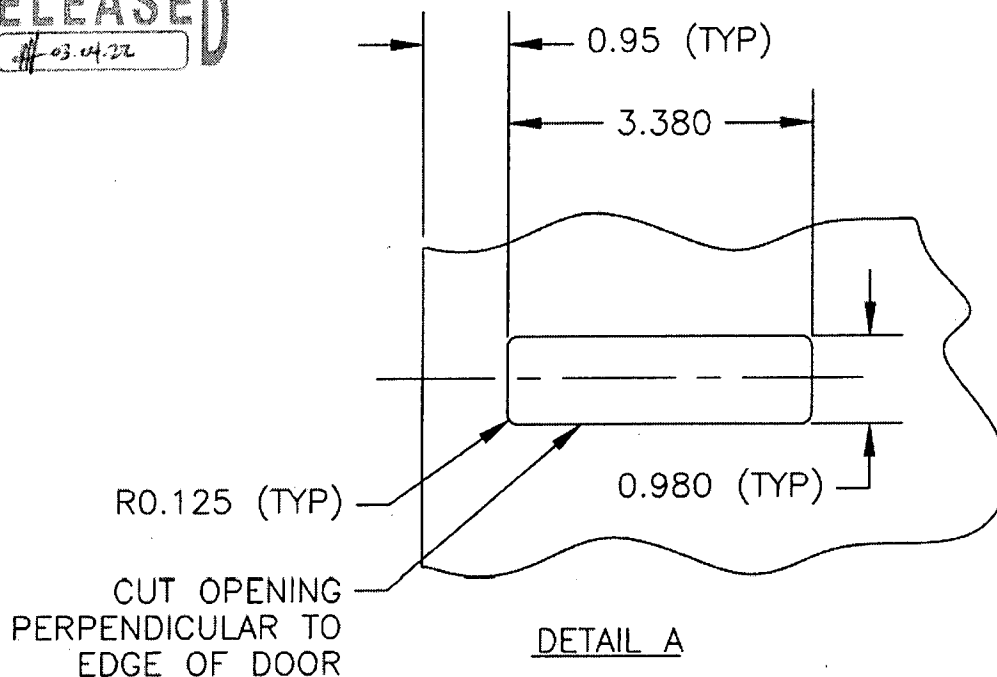
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DESIGN #	DRAWN BY JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3186	REV. A SHEET 3 OF 3
DATE 03.03.27		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED
03.04.22



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